

Date: Tuesday, 10/02/2009 3:07:01 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 45702		
Estimate Number	: 12105		
P.O. Number	:	Part Number	: D32011
This Issue	: 10/02/2009 S.O. No. :	Drawing Number	: D3201 REV B.
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 43611	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JULIE DAWSON</u>		
Comment	: Est Rev:A Removed from 9 Digit 06-01-25 JLM Est Rev:B Now on Waterjet 06-08-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2898 sf(s)/Unit Total : 1.7388 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040)  
 Identify for D3201-1  
 Batch: 106272 B 9-2-27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3201  
 Dwg Rev: B  
 Prog Rev: B

B 9-2-27

(8)

2-Deburr if necessary B 9-2-27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 9-2-27



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

109-02-28 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack N/A done at 2.0

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:07:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 45702

Part Number: D32011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(x8)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mf

09/03/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/03/02

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(8x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 76

9/3/02

8

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

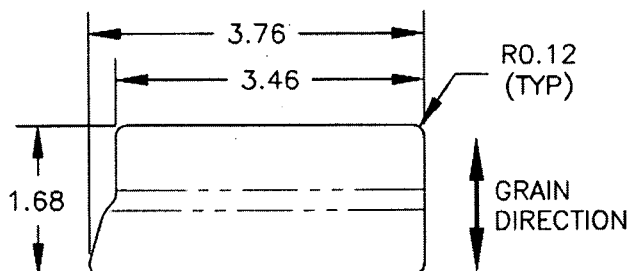
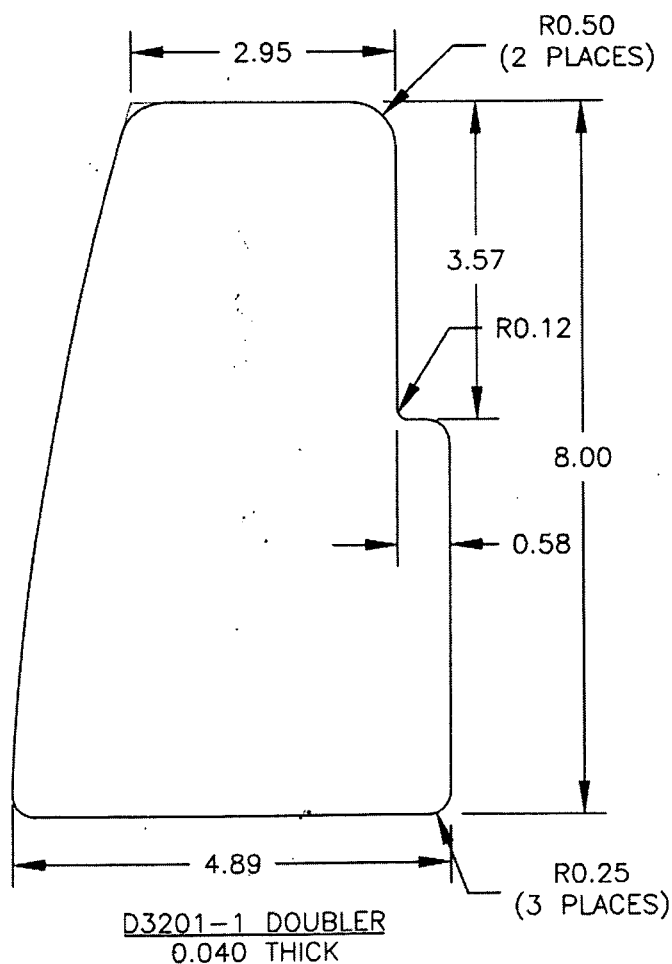
**NOTE:** Date & initial all entries



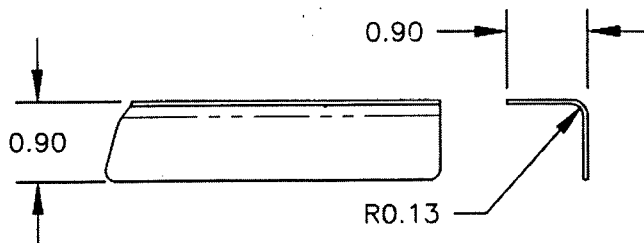


DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3201 REV. B SHEET 1 OF 1
DATE	03.11.03	TITLE	DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE		
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4		

RELEASED  
03.11.04



D3201-3/-4 ANGLE  
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)  
D3201-4 ANGLE (BEND OPPOSITE)  
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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NO. HS702

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